

Date: Tuesday, 16/12/2008 2:14:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID RH
Job Number : 44130	
Estimate Number : 10720	
P.O. Number :	Part Number : D350591214
This Issue : 16/12/2008 S.O. No. :	Drawing Number : D3078 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 43691	Material :
Written By :	Due Date : 09/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 08.12.16</u>	
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC	
Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM	
Est Rev:C 06-06-27 Revised as per DSI9340 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



for JLD 09/02/19



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG002

2.0

D2622120C

Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

.5 D2622-120

Extrusion

344064

~~344064~~

SAD 09-02-02

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SAD 09-02-02

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1

End Plate

341031
341447

16.09.02.09 4

6.0	D30631	Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3063-1

Support

341031

16.09.02.09 4

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod *M108031*

3-Grind End Plate flush

16.09.02.09 4
16.09.02.09 4
16.09.02.09 4

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09.02.10

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/02/10 x4PH

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.09.02.10 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 44130

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-02-10 (4)

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B43858

SAD 09-02-10 (4)

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B43759

SAD 09-02-10 (4)

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M110468

SAD 09-02-10 (4)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD 09-02-10 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/02/10 (4) (24)

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B41447

SAD 09-02-12 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44130

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M108039

4-Grind End Plate flush

FL 09.02.12 4
FL 09.02.12 4
FL 09.02.12 4
SAD 09-02-12 (4)

19.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 0902-13 (4)

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 02.13 (4)
RH

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

FL 09/02/17 (4)

22.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 9:15am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45am

FL 09-02-12 (4)

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

FL 09/02/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 44130

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20902-18 (4)



Comment: Inspect Powder Coat and Wing Walk

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

26.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

44701

27.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

44700

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total : 4.0000 f(s)

Rubber Extrusion

4 X 3"

Batch:

34509

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2")

Abrasion Strip

42437

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44130

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	AN335A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M108827

31.0	AN411A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt M108605

32.0	AN413A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M110865

33.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M110139

34.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M110523

35.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M109798

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44130

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M109282

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location: 80

PPP Rev: 0

alabo

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. *4430*

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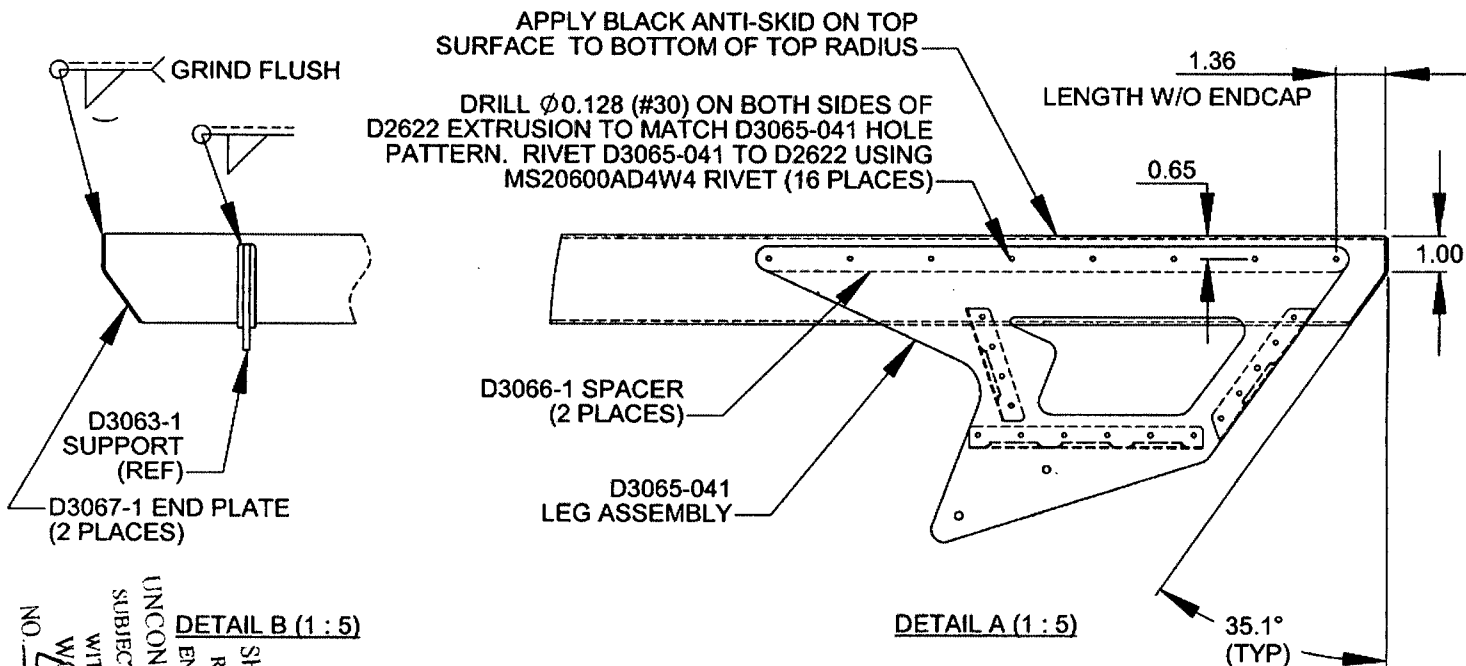
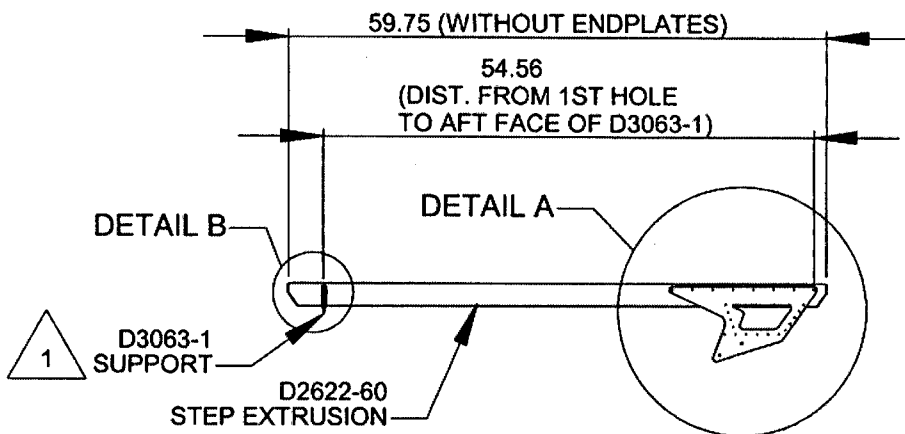
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		TITLE	SHEET 2 OF 2
02.09.11		STEP ASSEMBLY, HI SHORT	SCALE 1:20

RELEASED
02.09.2004



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